

Work Order ID 142032

Wednesday, March 09, 2016 10:39:23 AM

142032

Page 1

Item ID: D5377-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw
Start Date: 3/17/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 3/31/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: MLS Date: MAR 09 2016 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5377	A								

120 0.00

120

Waterjet FLOW WATER JET
Memo 0.09
FLOW CNC Waterjet Cut Blank as per D5377-1_blank File

(12) ac 16/03/15

130 0.01

130

HAAS 1 HAAS CNC VERTICAL MACHINING #1 0.14

HAAS CNC vertical machine #1
Memo
1-Inspect material for defects or damage prior to machining
2-Machine as per FolioFB448 and Dwg
FOLIO REV: AA
DWG REV: A
3-Deburr

11 1 DAS 14 9-39 16/03/16 PTO

DQA:

Date: 16.04.13



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed

Date: 16/03/38

Work Order update only ☐

Work Order: <u>142032</u> Part No. <u>5377-1</u> NCR No. <u>16-5678</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; font-size: small;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☒</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☒	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date: <u>16-3-18</u>	Step #: <u>130</u>	QTY Effective: <u>1</u>		MRB (QSI042) Approval DAS 9 <u>16-03-29</u> 9-89																																																																	
Description Work Order Deviation		Disposition		Completed By <u>JK</u> <u>16-3-18</u> Lead hand / Supervisor Approval Verification <u>B.A 16/03/18</u> QC / QA Coordinator Approval DAS 9 <u>16-03-21</u> 9-89																																																																	
1 part engraving went .050 too deep and digged in the part 4 dimension .756 is .730 R.C. errors in program		Scrap + no replace program was updated by <u>TP</u>																																																																			
Root Cause <table style="width:100%; font-size: x-small;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td></tr> <tr><td>Doc/Data ☒</td><td>Offset/Setup ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td></tr> </table>		Environment ☐	No Re-verification ☐	Design ☐	Operator ☐	Doc/Data ☒	Offset/Setup ☐	Equip/Tooling ☐	Supplier ☐	Handling/Pre ☐	Training ☐	Material ☐	Use for Testing ☐	Internal Transport ☐	Poor Information ☐	Tribal Knowledge ☐	Rushing ☐	LOA ☐	Product Improvement ☐	Substation ☐	Process Improvement ☐	Past Expiry Date ☐	Manufacturing Process ☐	Misidentified ☐	Past Due ☐	FAULT CATEGORY <table style="width:100%; font-size: x-small;"> <tr><td>Pressure/Forced ☐</td><td>Temperature/Cure ☐</td><td>Power Loss/Surge ☐</td><td>Positioned Wrong ☐</td></tr> <tr><td>Bending ☐</td><td>Set-up ☐</td><td>☒ Folio/Program</td><td>Outside Dimensions ☐</td></tr> <tr><td>Centre Not Concentric ☐</td><td>BOM/Route ☐</td><td>Grain ☐</td><td>Over/Under tolerance ☐</td></tr> <tr><td>Cracks ☐</td><td>Broken/Damage/Defect ☐</td><td>Weld ☐</td><td>Part Incorrect ☐</td></tr> <tr><td>Crimp/Kink/Ripple/Wave ☐</td><td>Inspection Incomplete/Unqualified ☐</td><td>Wrong Stock Pulled ☐</td><td>Part Lost/Missing ☐</td></tr> <tr><td>Cuffs ☐</td><td>Contamination ☐</td><td>Out of Sequence ☐</td><td>Part Moved ☐</td></tr> <tr><td>Crushing ☐</td><td>Countersink ☐</td><td>Off-set ☐</td><td>Drawing ☐</td></tr> <tr><td>Heat Treat ☐</td><td>Cut Too Short ☐</td><td>Mislabeled ☐</td><td>Finish ☐</td></tr> <tr><td>Wave/Twist in Tube ☐</td><td>Instructions Incomplete/Unclear ☐</td><td>Fit/Function ☐</td><td>Misread ☐</td></tr> <tr><td>Marks/Chatter ☐</td><td>Drill Holes ☐</td><td>Misaligned/off center ☐</td><td>Turning Sequence ☐</td></tr> </table>				Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Bending ☐	Set-up ☐	☒ Folio/Program	Outside Dimensions ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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		OTHER: ☐																																																																			

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Wednesday, March 09, 2016 10:39:23 AM

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bearpaw

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code
---------	--------	-----------

**Accept
Qty**

Reject Qty

Reject
Number

Insp.
Stamp

140

QC2- Inspect parts off machine FAI/FAIB

0.00

140

QC

Memo

0.00

Quality Control

14
9-39
11/03/16

150

QC8- Inspect parts - second check

0.00

150

QC

Memo

0.00

Quality Control


 16/03/21
 DAS
 45
 9-89

151

Identify as per dwg & Stock Location: 51438A 0.00

0.00

151

Packaging

Memo

0.00

Packaging

11 MAR 21 2016 DAS 6 8-8p

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 142032

Wednesday, March 09, 2016 10:39:23 AM

142032

Page 3

Item ID: D5377-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw
Start Date: 3/17/2016 Start Qty: 12.00 ***12*** Cust Item ID:
Required Date: 3/31/2016 Req'd Qty: 12.00 ***12*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190 QC Quality Control	Memo	0.02							

ML5 MAR 21 2016

ML5 MAR 21 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Misidentified ☐	Past Due ☐																																																														

Picklist Print

Wednesday, March 09, 2016 10:39:26 AM

Page 1

Work Order ID: 142032

142032

Parent Item: D5377-1

D5377-1

Parent Item Name: Bearpaw

Start Date: 3/17/2016

Required Date: 3/31/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 16-01-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased		No			sf	597.8730		66.94737			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

on 16/03/15

Location

Loc Qty

Loc Code

MAT

196.4

m134171

196.4

MAT018

401.473

m131661

1.473

m134372

400

89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

DART AEROSPACE LTD		Work Order:	142 032
Description: <i>Bearpaw</i>		Part Number:	D5377-1
Inspection Dwg: D5377 Rev: A		Page 1 of 1	

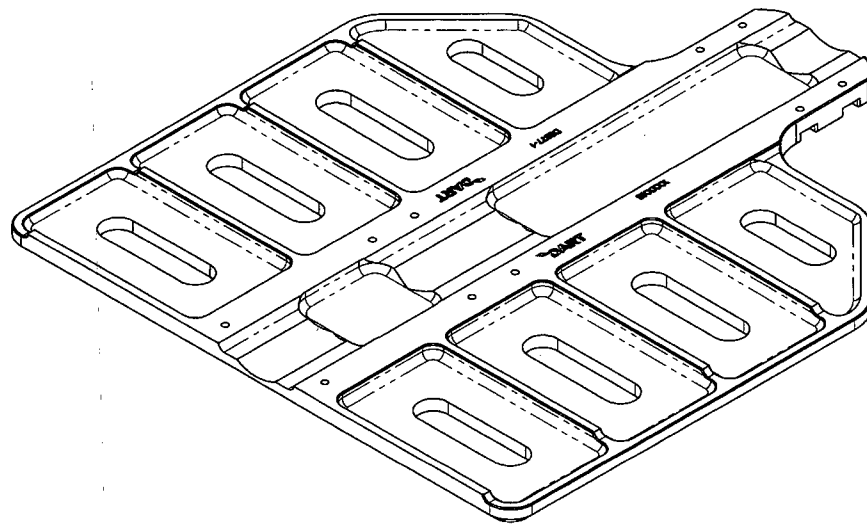
INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.38	$\pm .030$	.380	/		Vern ML-06	
3.00	$\pm .030$	5.000	/		"	
3.95	$\pm .030$	3.930	/		"	
1.38	$\pm .030$	1.375	/		"	
5.50	$\pm .030$	5.505	/		"	
1.72	$\pm .030$	1.720	/		"	
2.00	$\pm .010$	2.000	/		"	
15.44	$\pm .010$	15.440	/		M-topo	
4.688	$\pm .010$	4.688	/		Vern ML-06	
.756	$\pm .010$	.758	/		"	
.700	$\pm .010$	.700	/		"	
24.000	$\pm .030$	24.000	/		M-topo	
21.34	$\pm .030$	21.370	/		"	
6.40	$\pm .030$	6.400	/		"	
3.52	$\pm .030$	3.530	/		Vern ML-06	
.24	$\pm .030$	.248	/		"	
R.250	$\pm .030$	R.250	/		R-G	
30 X 45°	$\pm .030$	300 X 45°	/		Vern ML-06	
.50	$\pm .030$	.490	/		"	
.74	$\pm .030$	.733	/		"	
.950	$\pm .030$	.940	/		"	
Ø.261	$\pm .005$	Ø.260	/		"	
.500	$\pm .010$	.497	/		"	
Ø6 X 45°	$\pm .030$	Ø.050 X 45°	/		"	
.460	$\pm .010$	.468	/		"	
Ø.650	$\pm .010$	Ø.649	/		"	
.375	$\pm .010$	.380	/			

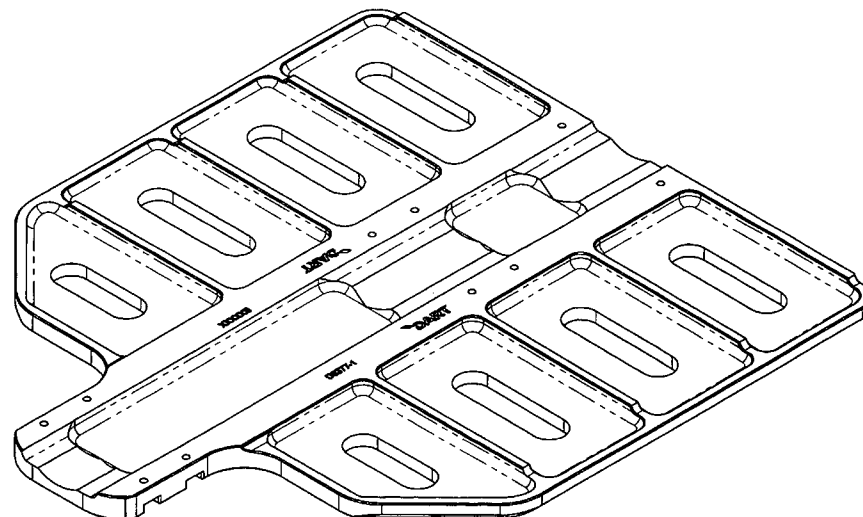
DAS Measured by: 14 9-39 <i>JL</i>		DAS Checked by: 45 9-89 <i>[Signature]</i>		QC Inspector:
Date: 16/03/16		Date: 16/03/21		Date: 20/03/21

Engineering Approval: (If necessary)	Date:
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Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



D5377-1 BEARPAW



NOTES:

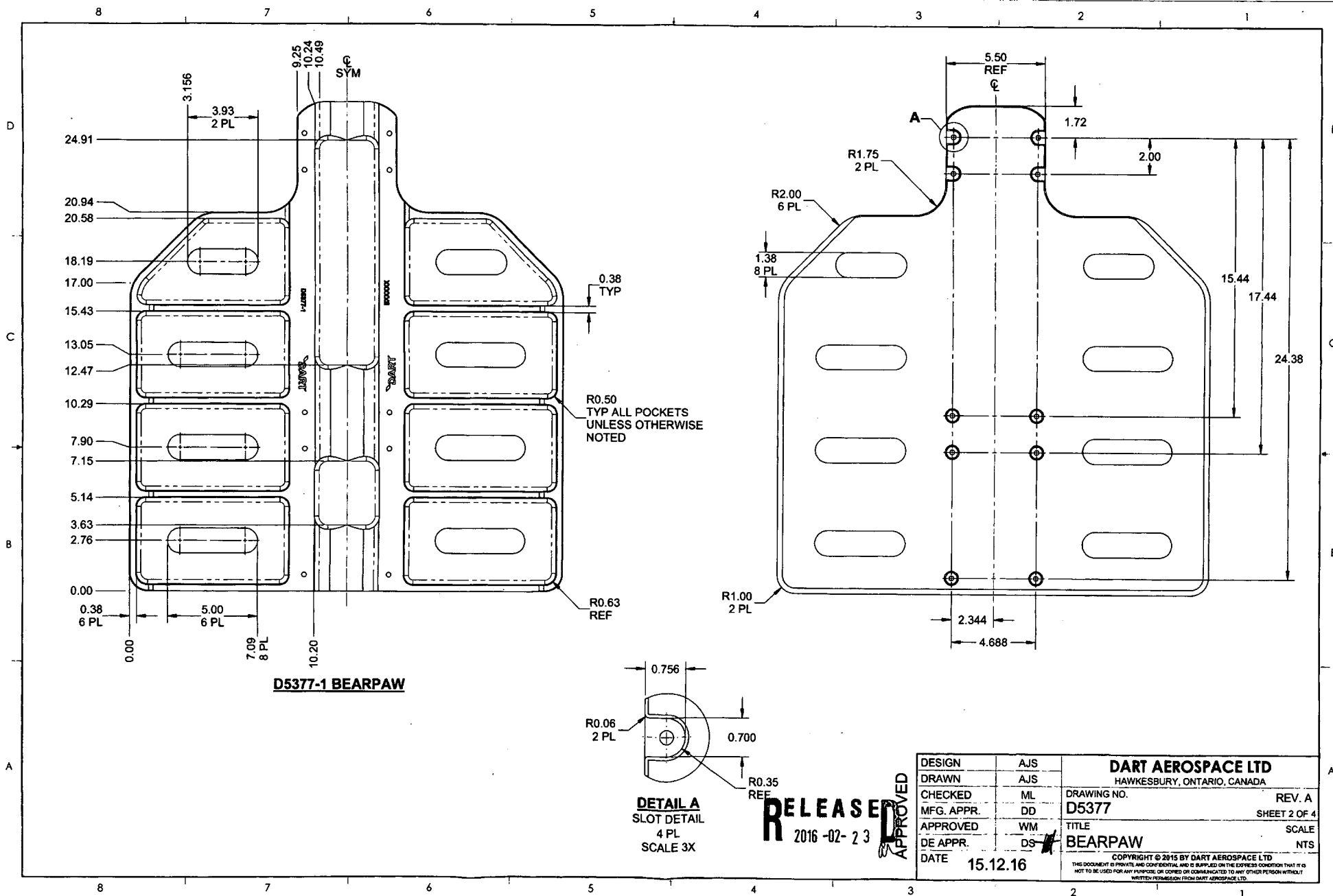
- 1) MATERIAL: BLACK UHMW TIVAR 1000 VIRGIN MATERIAL SHEET, 1.00 THICK
REF DART SPEC MUHMWB100
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3 0.010 - 0.012 DP WITH A MINIMUM 0.010 RAD
- 7) WEIGHT: 9.55 lbs
- 8) ENGRAVE "DART" LOGO AS SHOWN 0.010 - 0.012 DP WITH A MINIMUM 0.010 RAD
- 9) ALL NON DIMENSIONED FEATURES PER CAD FILE D5377-1-REVA.STP

RELEASED
2016-02-23
EAV 16-529

20160223 SA 142032

A NEW ISSUE		AJS	15.12.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	ML	DRAWING NO. D5377	
MFG. APPR.	DD		
APPROVED	WM	TITLE BEARPAW	
DE APPR.	DS		
DATE	15.12.16	SHEET 1 OF 4 SCALE NTS	

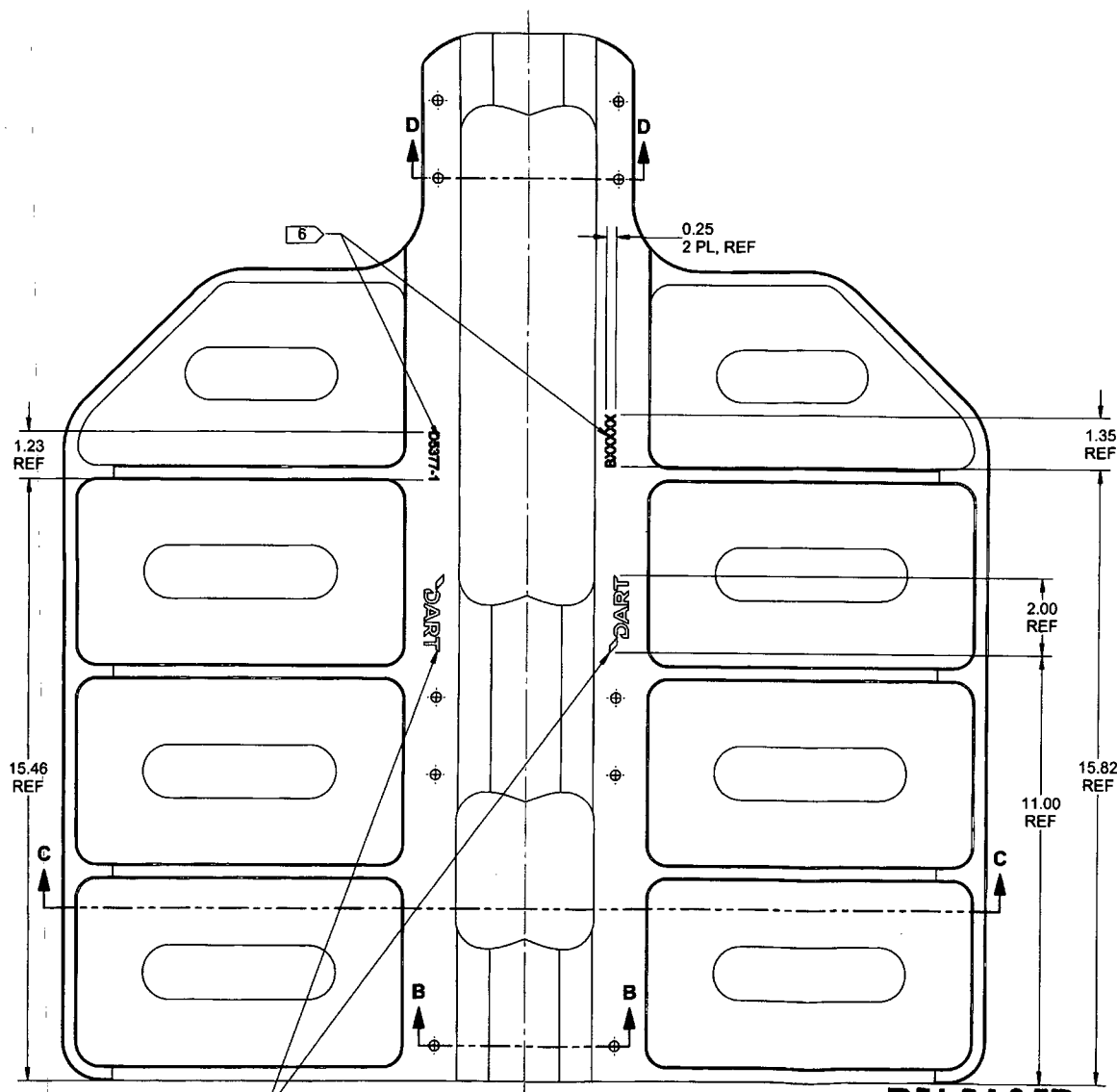
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WRITTEN PERMISSION FROM DART AEROSPACE LTD.



8 7 6 5 4 3 2 1

D
C
B
A

D
C
B
A



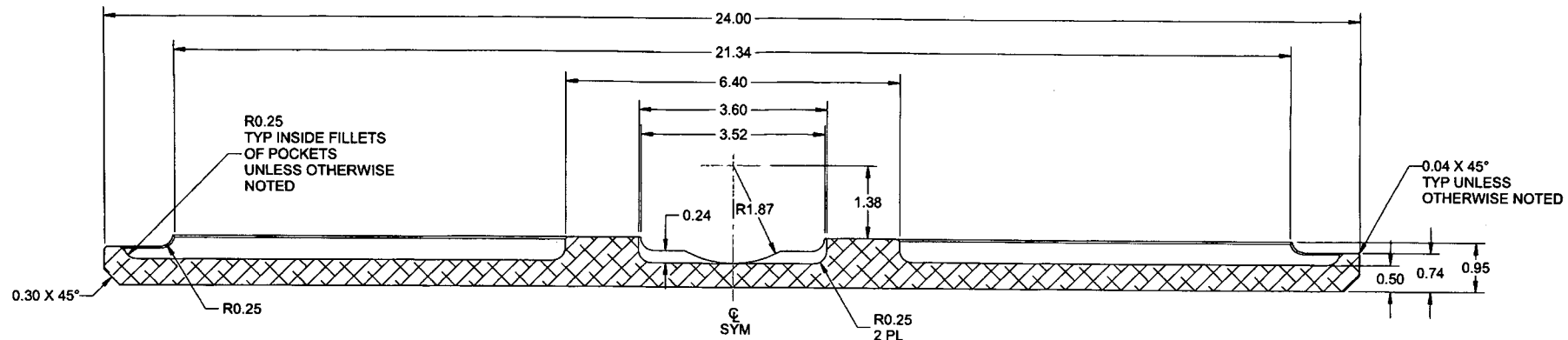
D5377-1 BEARPAW
(SUPPLEMENTAL VIEW)

RELEASED
2016-02-23

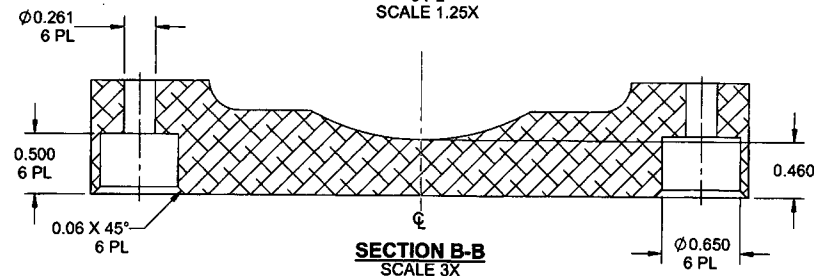
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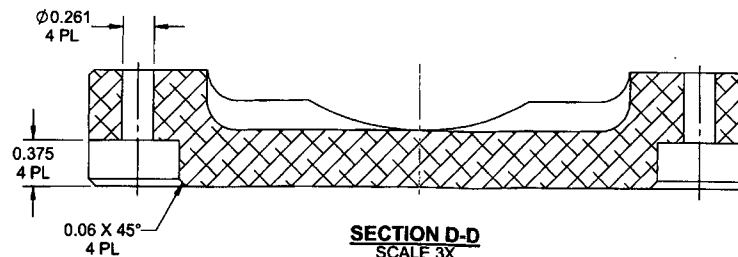
8 7 6 5 4 3 2 1



SECTION C-C
3 PL
SCALE 1.25X



SECTION B-B
SCALE 3X



SECTION D-D
SCALE 3X

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